

ITEM #	QTY	PART #	PART TITLE
-3	1	RB T101576-3	MANDREL ASSY
-7	1	RB T101576-7	STAND ASSY
-13	1	RB T101576-13	BASE
-19	1	RB T101576-19	PLATE
-29	1	RB T101576-29	206 PLUG
-31	1	RB T101576-31	206L PLUG
32	1	McMaster#2198A860 OR EQUIV.	HIGH-TEMP. CIRCULAR MOUNTABLE LEVEL 1-7/16" BASE DIA. X 1/2" OVERALL HT.
33	2	McMaster#92185A564 OR EQUIV.	SS SOCKET HEAD SCREW 1/4"-28 X 1" LG.
34	1	McMaster#92185A673 OR EQUIV.	SS SOCKET HEAD SCREW 3/8"-24 X 1" LG.
35	2	NAS1149C0463R	WASHER
36	1	NAS1149C0663R	WASHER

(THIS VIEW IS SHOWN FOR REFERENCE ONLY)

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

RB T101576 BALANCE SET

13

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY LOCTITE LB 771 NICKEL BASED ANTI SEIZE ON THREADS OF ITEM 34 THEN ASSEMBLE WITH ITEM -3

9) INSTALL ITEM 34 HAND TIGHT

10) ASSEMBLE TOOL WITH ITEM -29

11) ITEM -31 MUST BE INDIVIDUALLY PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

12) ITEM -19 MUST BE INDIVIDUALLY PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

13) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

H	ITEM -5 DIMENSION 118.0° ADDED	19-865										
G		VM										
UPDATED DRAWING TEMPLATE AND HARDWARE DASH NUMBERS TOOL TITLE WAS "BALANCE SET - MAIN & TAIL ROTOR" IS "BALANCE SET" ITEM 32 WAS GEIER & BLUHM #2-14000 IS McMaster#2198A860 OR EQUIV. ITEM 35 WAS MCMASTER-CARR#98017A660 IS NAS1149C0463R ITEM 36 WAS MCMASTER-CARR#98017A200 IS NAS1149C0663R ITEM 37 WAS MCMASTER-CARR#9528K29 IS McMaster#9642K63 OR EQUIV. ITEM 40 WAS MCMASTER-CARR#90257A033 IS McMaster#94805A224 OR EQUIV. ITEM 41 WAS MCMASTER-CARR#94805A217 IS McMaster#94805A224 OR EQUIV. ITEM 42 WAS MCMASTER-CARR#97395A485 IS McMaster#98380A540 OR EQUIV. -5 REMOVED UNDERCUT. DIM WAS ϕ .752-.751 IS ϕ .7525-.7510. DIM WAS R.010 MAX TYP IS R.008 MAX 5 PL -9 DIM WAS ϕ .510-.436 IS ϕ .473. DIM WAS R.010 MAX IS R.008 MAX -11 DIM WAS ϕ .249-.248 IS ϕ .250+0.000/-0.001 -13 DIM WAS .255-.250 IS 0.260-.255 2 PL -21 DIM WAS 30° IS 31.0° -29, -31 DIM WAS ϕ .396-.390 THRU ALL \checkmark ϕ .491 X 90°, NEAR SIDE DIM IS ϕ .397 THRU 0.05 X 45.0° CMF, NEAR SIDE. ADDED 0.0015 FLATNESS GD&T CALLOUT. PERPENDICULARITY TOLERANCE WAS 0.0002 IS 0.0015		KPT										
REV.	DESCRIPTION	ECN # BY										
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 50%;">DESIGN</td> <td style="width: 50%;">KPT</td> </tr> <tr> <td>DRAWN</td> <td>KPT</td> </tr> <tr> <td>CHECKED</td> <td>MBB</td> </tr> <tr> <td>MFG. APPR.</td> <td>FK</td> </tr> <tr> <td>APPROVED</td> <td><i>WJ</i></td> </tr> </table>		DESIGN	KPT	DRAWN	KPT	CHECKED	MBB	MFG. APPR.	FK	APPROVED	<i>WJ</i>	A
DESIGN	KPT											
DRAWN	KPT											
CHECKED	MBB											
MFG. APPR.	FK											
APPROVED	<i>WJ</i>											
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. H										
TOOL PART # RB T101576 TITLE BALANCE SET		SHEET 1 OF 11										
DATE 2019-08-20		SCALE NTS										

ITEM #	QTY	PART #	PART TITLE
-5	1	RB T101576-5	MANDREL
-21	1	RB T101576-21	PLUG
37	1	McMaster#9642K63 OR EQUIV.	440C SS BALL 3/4" DIA.
38	1	McMaster#2857T128 OR EQUIV.	VITON O-RING 3/32 THK. X 9/16" ID. X 3/4" OD.

D

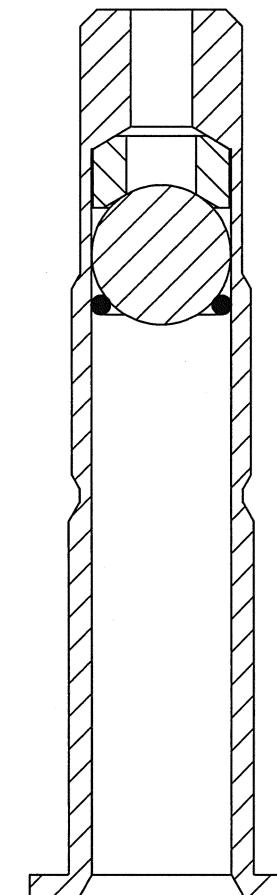
D

C

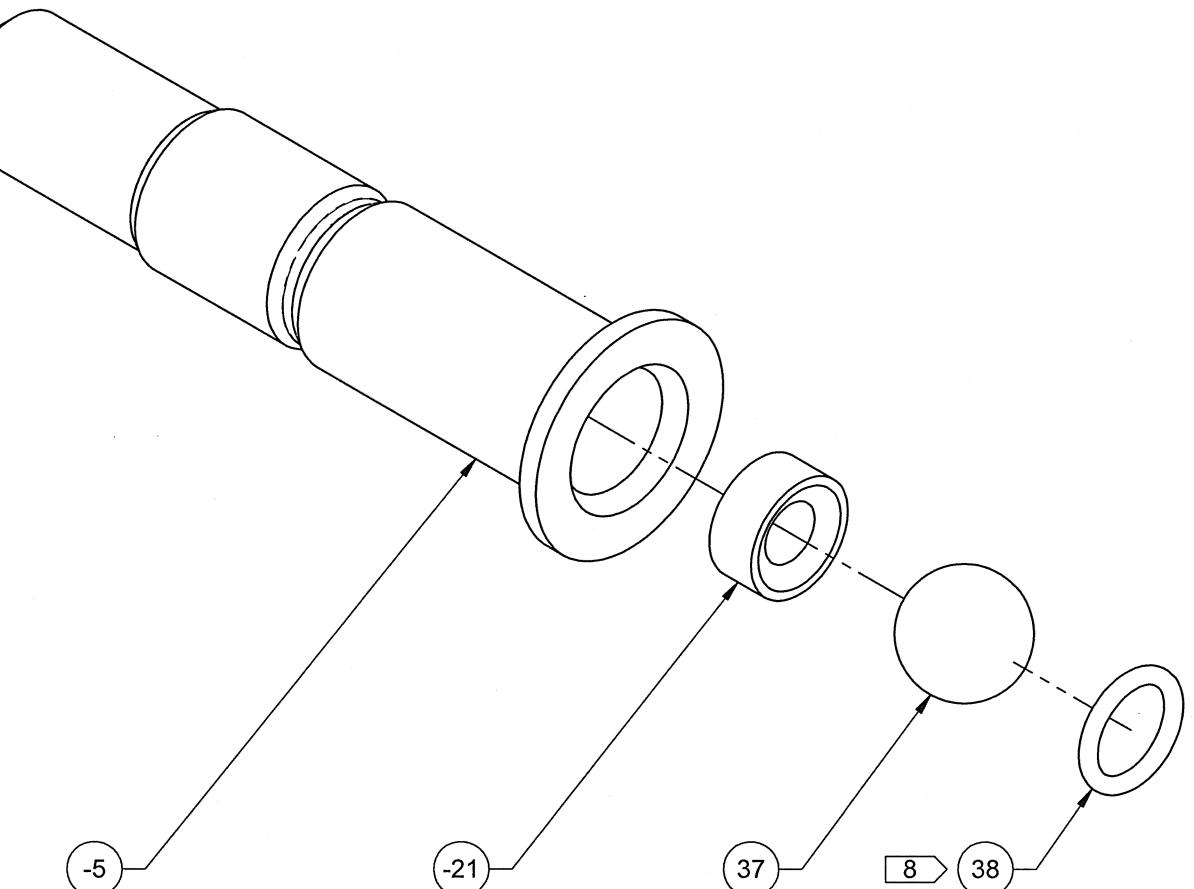
C

B

B



(THIS VIEW IS SHOWN FOR REFERENCE ONLY)



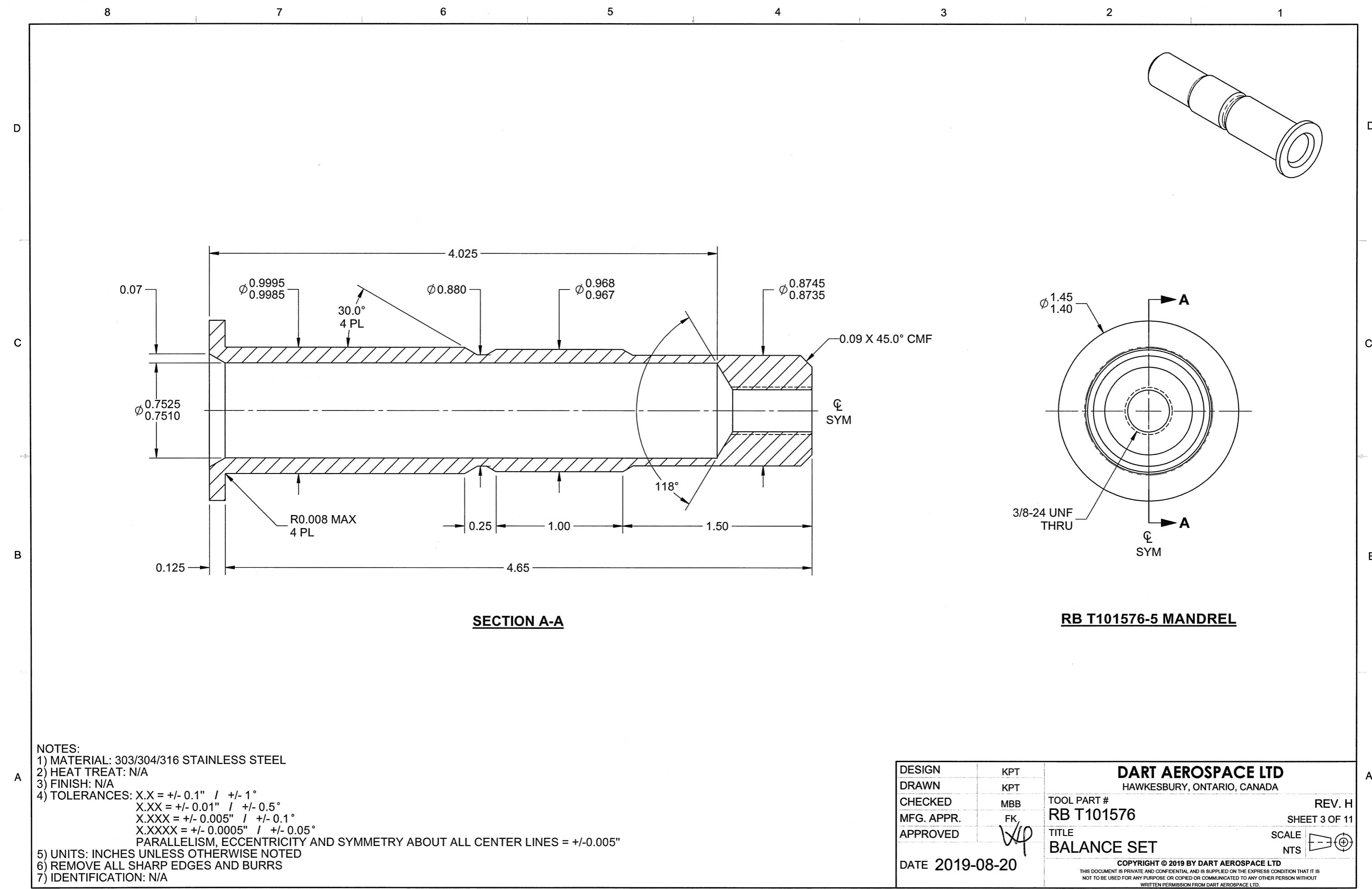
RB T101576-3 MANDREL ASSY

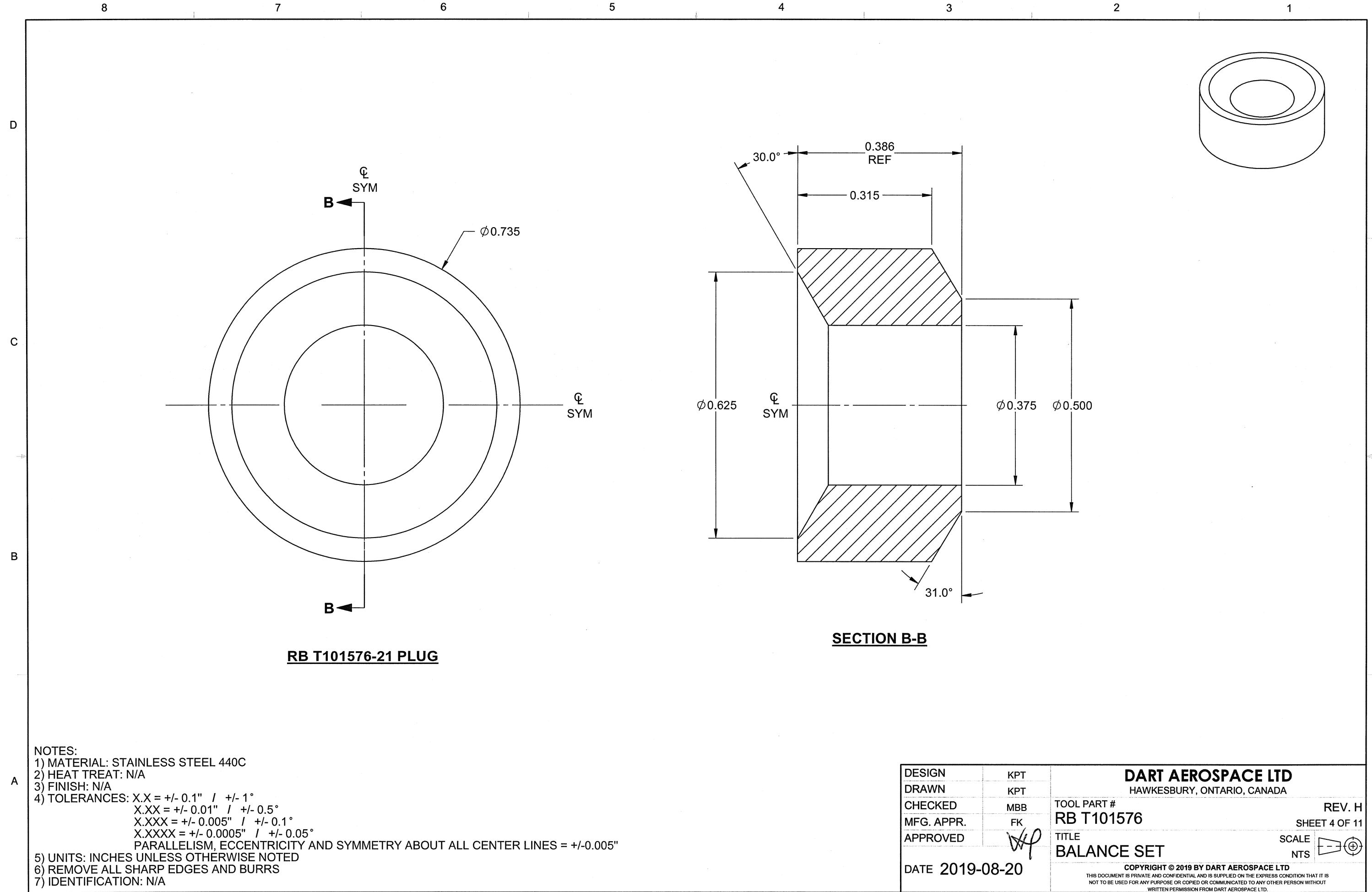
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) APPLY MOLYKOTE 55 OR EQUIVALENT ON ITEM 38 THEN ASSEMBLE WITH ITEM -5 AND REMOVE EXCESS

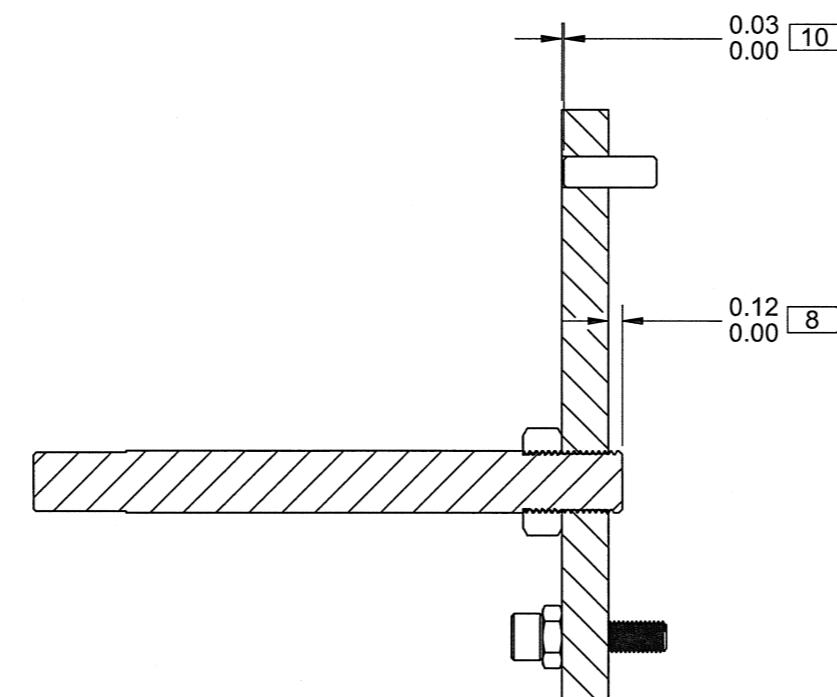
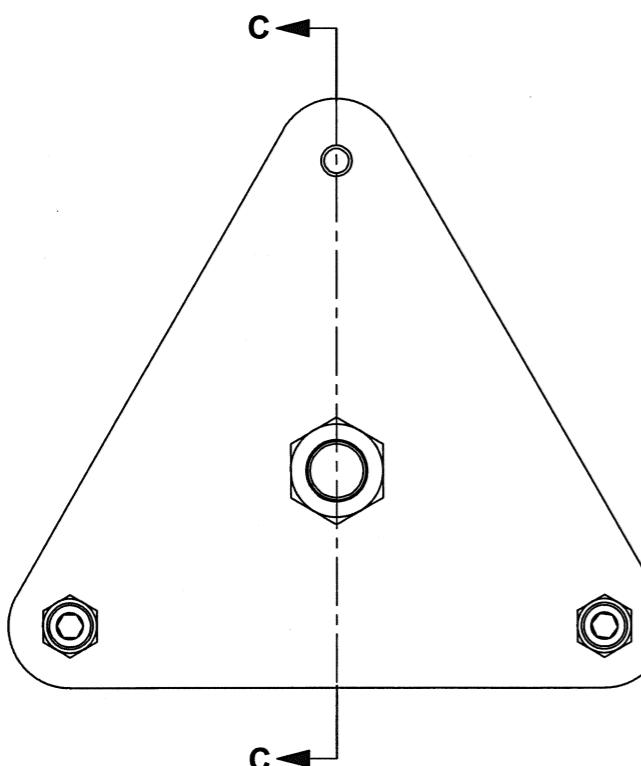
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	REV. H	
MFG. APPR.	FK	SHEET 2 OF 11	
APPROVED	WJ	TITLE	
DATE 2019-08-20		BALANCE SET	
TOOL PART # RB T101576			
SCALE NTS			

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

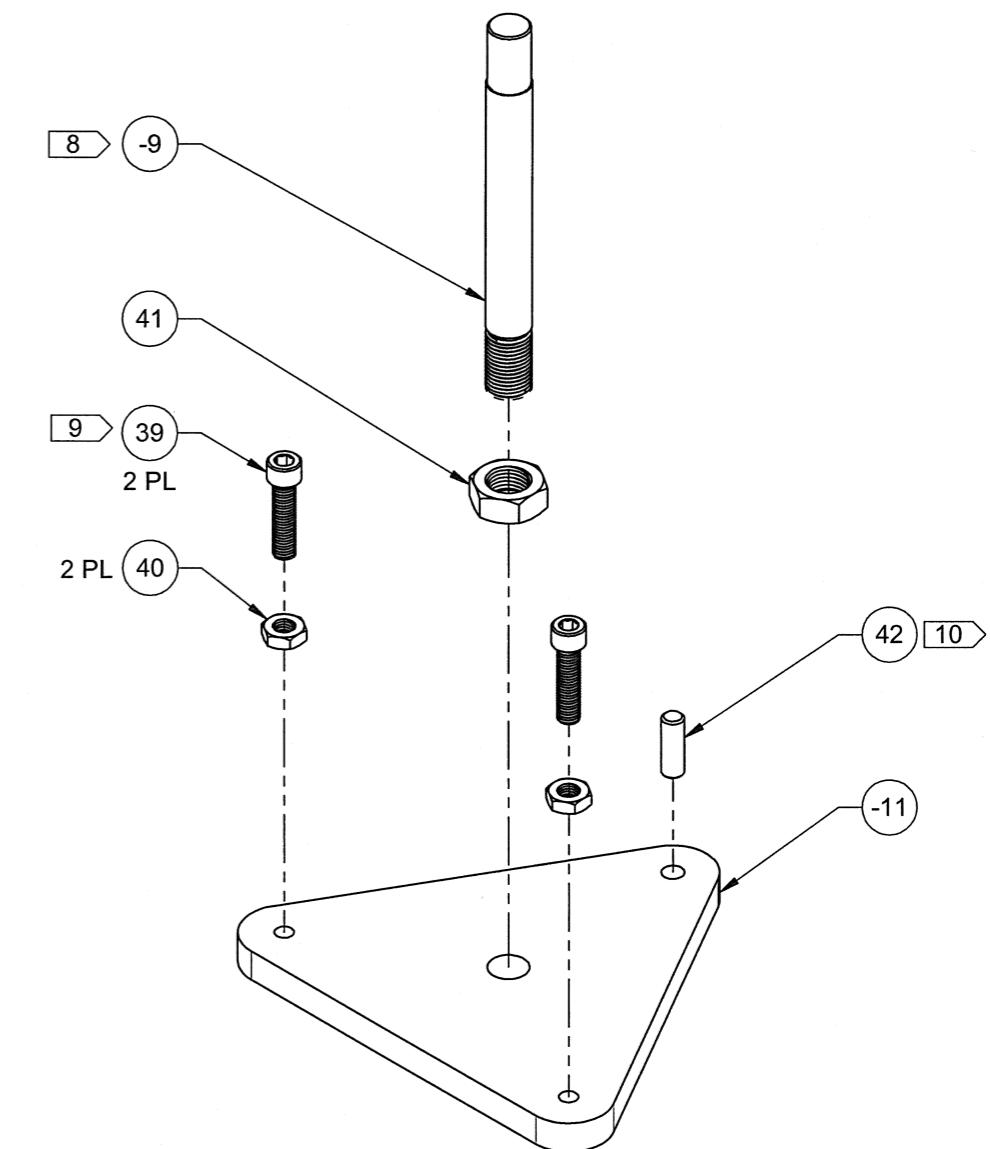




ITEM #	QTY	PART #	PART TITLE
-9	1	RB T101576-9	STAND
-11	1	RB T101576-11	PLATE
39	2	McMaster#92185A564 OR EQUIV.	SS SOCKET HEAD SCREW 1/4"-28 X 1" LG.
40	2	McMaster#94805A209 OR EQUIV.	SS HEX NUT 1/4"-28 X 5/32" HT.
41	1	McMaster#94805A224 OR EQUIV.	SS HEX NUT 1/2"-20 X 5/16" HT.
42	1	McMaster#98380A540 OR EQUIV.	SS DOWEL PIN 1/4" DIA. X 3/4" LG.



SECTION C-C



RB T101576-7 STAND ASSY

NOTES:

1) MATERIAL: N/A

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY LOCTITE LB 771 NICKEL BASED ANTI SEIZE ON THREADS OF ITEM -9 THEN ASSEMBLE WITH ITEM 41 AND ITEM -11 AS SHOWN

9) APPLY LOCTITE LB 771 NICKEL BASED ANTI SEIZE ON THREADS OF ITEM 39 THEN ASSEMBLE WITH ITEM 40 AND ITEM -11 AS SHOWN

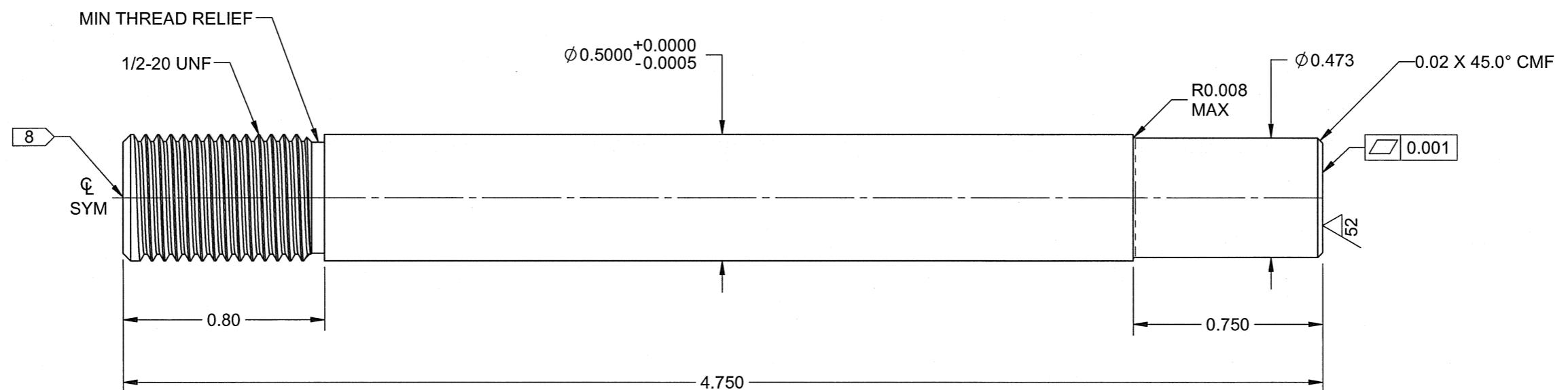
10) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 41 WITH ITEM -11 AND REMOVE EXCESS

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	REV. H	
MFG. APPR.	FK	SHEET 5 OF 11	
APPROVED	WJP	TOOL PART #	
		RB T101576	
		TITLE	
		BALANCE SET	
DATE 2019-08-20		SCALE	
		NTS	
COPRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS			
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT			
WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

D

D



RB T101576-9 STAND

NOTES:

- 1) MATERIAL: STAINLESS STEEL 440C
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 $X.XX = +/- 0.01" / +/- 0.5°$
 $X.XXX = +/- 0.005" / +/- 0.1°$
 $X.XXXX = +/- 0.0005" / +/- 0.05°$
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	REV. H	
MFG. APPR.	FK	SHEET 6 OF 11	
APPROVED	<i>WY</i>	SCALE	NTS
TOOL PART #		RB T101576	
TITLE		BALANCE SET	
DATE 2019-08-20			

COPYRIGHT © 2019 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8

7

6

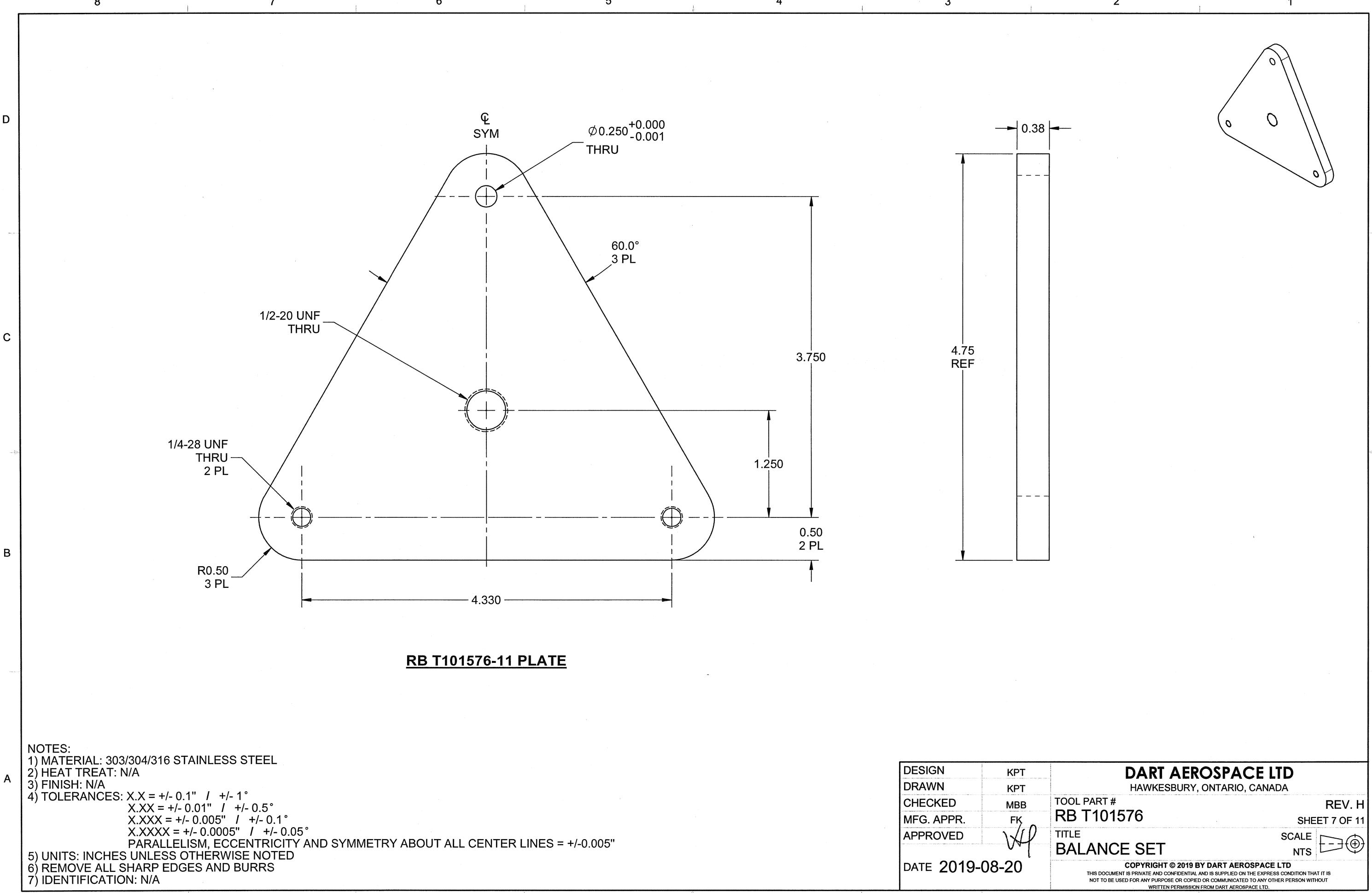
5

4

3

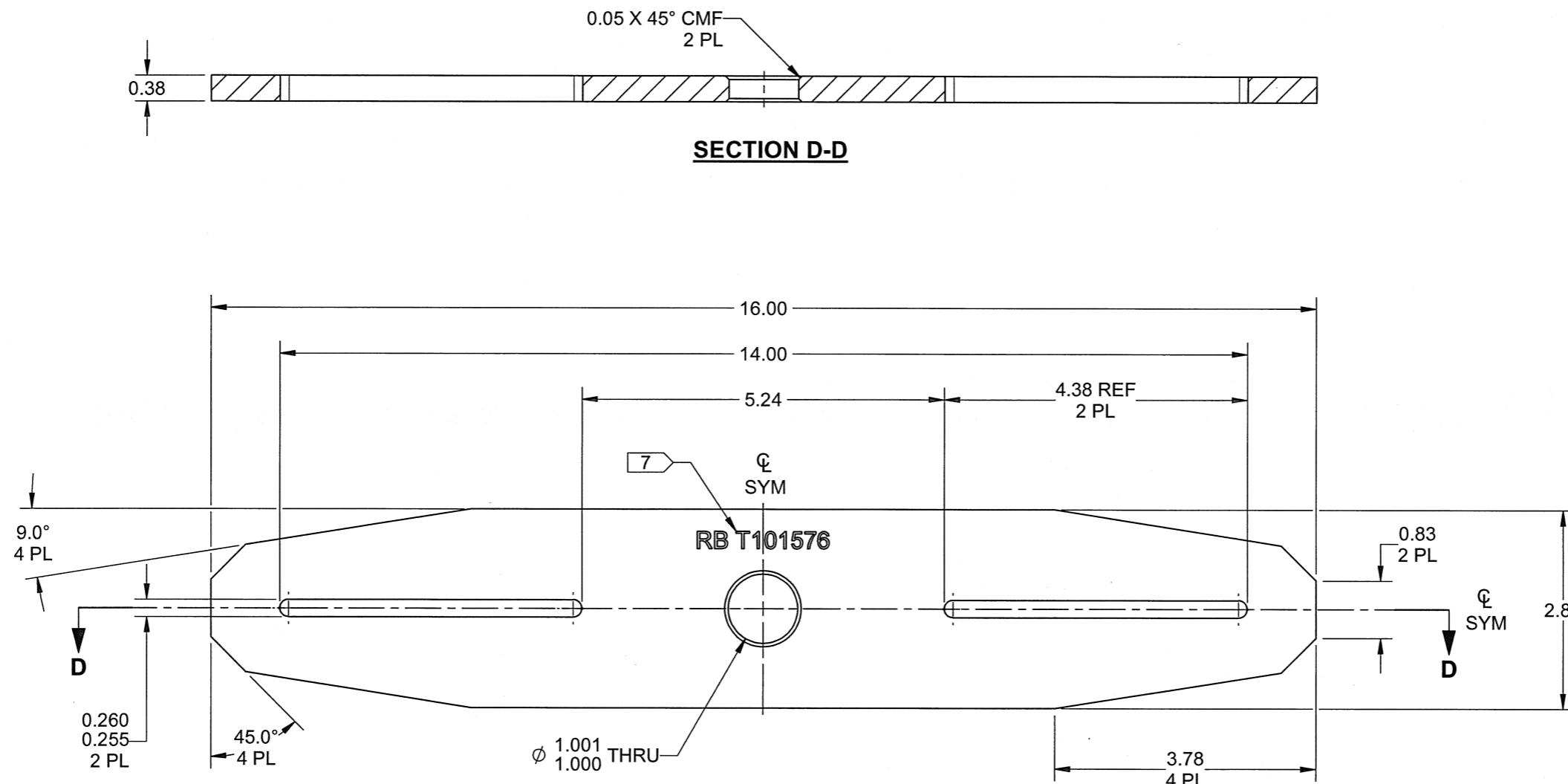
2

1



D

D

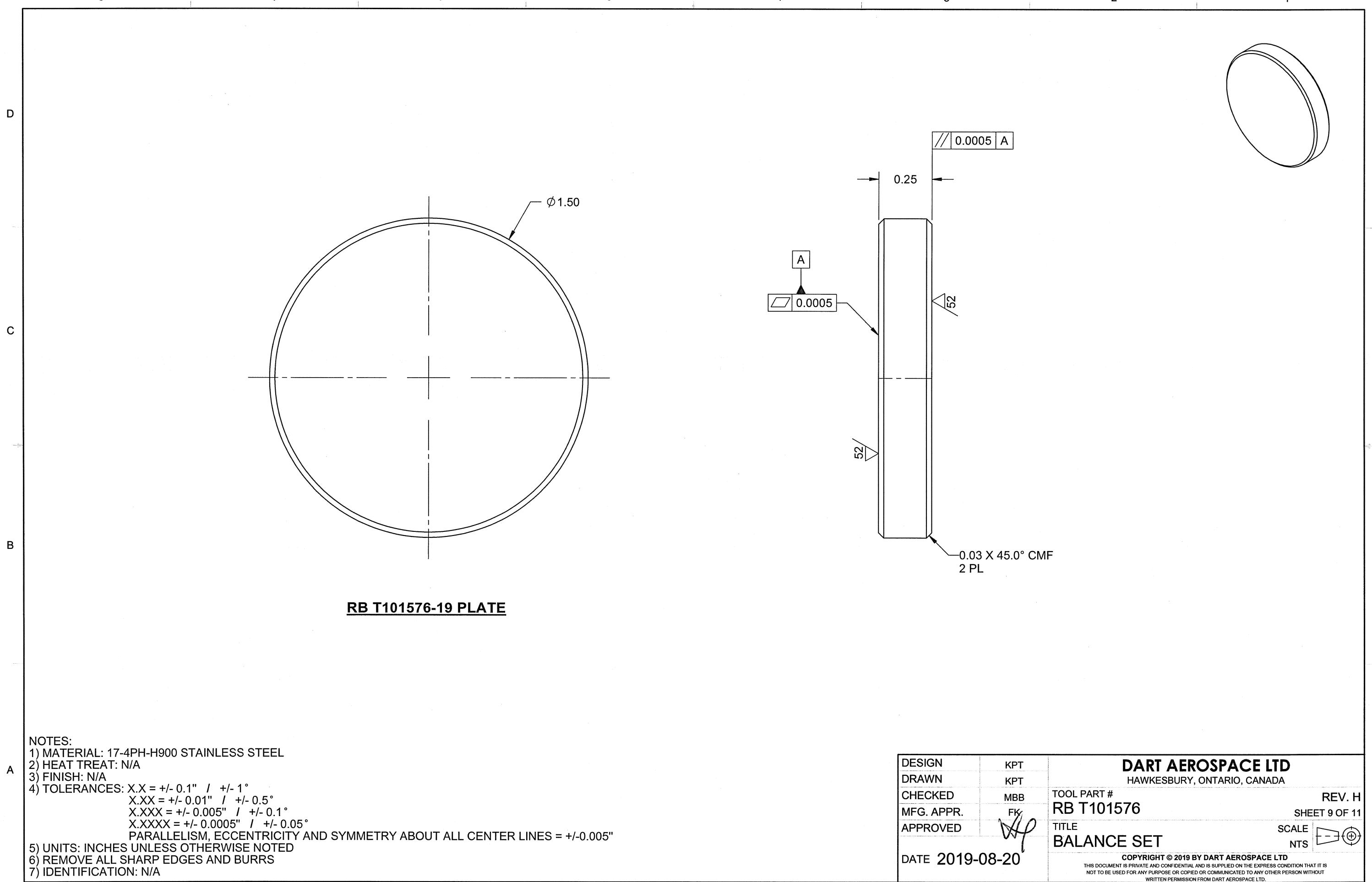
RB T101576-13 BASE

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB		
MFG. APPR.	FK		
APPROVED	WJP		
DATE 2019-08-20		TOOL PART #	RB T101576
		TITLE	BALANCE SET
		SCALE	NTS

COPYRIGHT © 2019 BY DART AEROSPACE LTD
 THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
 NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
 WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB		
MFG. APPR.	FK		
APPROVED	<i>[Signature]</i>		
TOOL PART #		REV. H	
RB T101576		SHEET 9 OF 11	
TITLE		SCALE	
BALANCE SET		NTS	
DATE 2019-08-20			

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

